

326 8390



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18034
Job Sheet 186984



Part No: RBT18034

Job Qty: 10 pcs

Part Name: Main Rotor Pitch Link Protectors



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18034 Rev 3 IPP Rev A 17.12.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	10 pcs	1/11/19		0.00	10.00	Small Fab - 1	EXT-LOAD	AP, 2019/02/28 Michel
							Small Fab - 2	EXT-LOAD 2	
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	10 pcs	1/11/19		0.00	0.00	QC 5 - 10		DAS MAR 05 2019 28 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	10 pcs	1/11/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S157753



Part: RBT18034

Job No: 186984

Serial No/Batch: S157753

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 02/28/19

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	10 pcs	1/11/19	0.00 0.00	QC 21 - SA - 21	D-16 21 0-16
					QC 21 - SA - 70	
Part Op 110 - Small Fab-3 (Small Fab) -Assemble as per DWG. -Cut lanyards to _____ -Ink stamp T/N on each -9 flag Descriptions: 120 - QC5 (QC5- Inspect part completeness to step on W/O) 130 - Packaging3-1 (Identify as per dwg & Stock Location:_____) Bag and tag (part number and revision level) 140 - QC21 (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
CL-2-C	Lanyard Wire	20 ft (2 ea)	110-Small Fab - 1	5119833		
CL-2-F	Ferrule	80 Ea (8 ea)	110-Small Fab - 1	5136901		
NAS1756-12	Remove Before Flight	40 Ea (4 ea)	110-Small Fab - 1	5055799		
RBT18034-1	Hose	40 Ea (4 ea)	110-Small Fab - 1	5147738		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
110-Small Fab - 1	CL-2-C	20	493	0		
	CL-2-F	80	399	0		
	NAS1756-12	40	486	0		
	RBT18034-1	40	0	0		
Part Specifications						
Specifications could not be found.						



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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/11/19	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	10 pcs		1/11/19	0.00	10.00	Small Fab-3		
120	QC	10 pcs		1/11/19	0.00	0.00	QC5		
130	Packaging	10 pcs		1/11/19	0.00	0.00	Packaging3-1		
140	QC21-SA	10 Ea		1/11/19	0.00	0.00	QC21		

Part Op 110 - -Assemble as per DWG. -Cut lanyards to _____ -Ink stamp T/N on each -9 flag
Descriptions: 130 - Bag and tag (part number and revision level)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CL-2-C	Lanyard Wire	20 ft (2 ea)	90-Start up Operation	
CL-2-F	Ferrule	80 Ea (8 ea)	90-Start up Operation	
NAS1756-12	Remove Before Flight	40 Ea (4 ea)	90-Start up Operation	
RBT18034-1	Hose	40 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CL-2-C	20	515	0
	CL-2-F	80	100	0
	NAS1756-12	40	236	0
	RBT18034-1	40	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

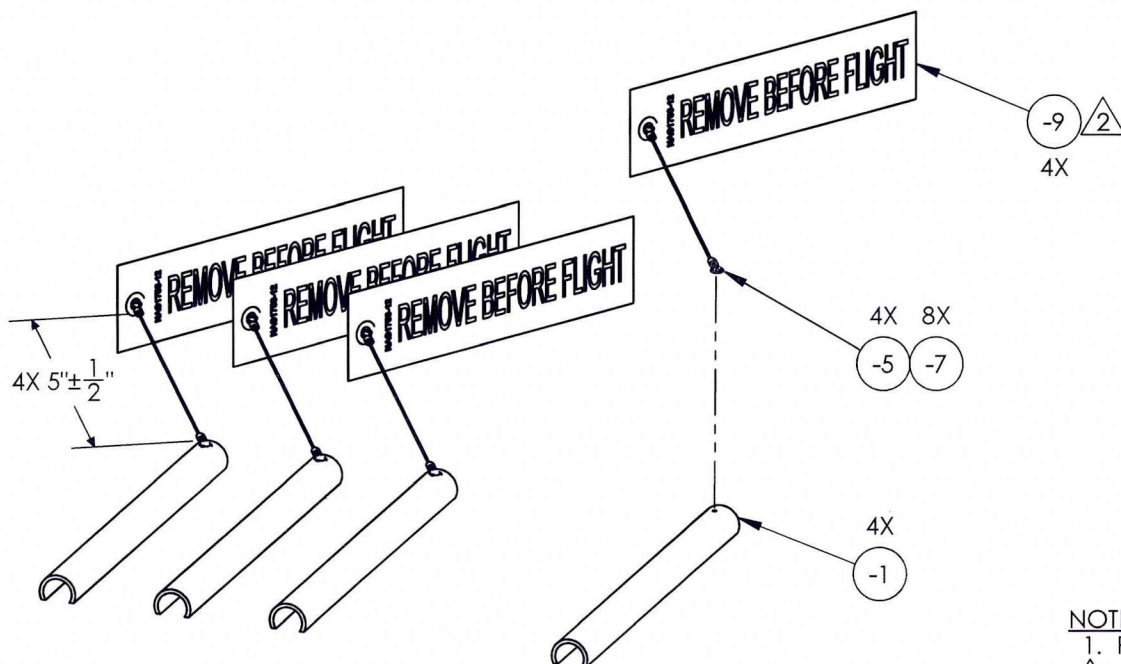
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																					
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			Completed By																																																																						
			Lead hand / Supervisor Approval Verification																																																																						
			QC / QA Coordinator Approval																																																																						
Root Cause <table style="width:100%; border: none;"> <tr> <td style="border: none;">Environment ☐</td> <td style="border: none;">No Re-verification ☐</td> <td style="border: none;">Pressure/Forced ☐</td> <td style="border: none;">Temperature/Cure ☐</td> <td style="border: none;">Power Loss/Surge ☐</td> <td style="border: none;">Positioned Wrong ☐</td> </tr> <tr> <td style="border: none;">Design ☐</td> <td style="border: none;">Operator ☐</td> <td style="border: none;">Bending ☐</td> <td style="border: none;">Set-up ☐</td> <td style="border: none;">Folio/Program ☐</td> <td style="border: none;">Outside Dimensions ☐</td> </tr> <tr> <td style="border: none;">Doc/Data ☐</td> <td style="border: none;">Offset/Setup ☐</td> <td style="border: none;">Centre Not Concentric ☐</td> <td style="border: none;">BOM/Route ☐</td> <td style="border: none;">Grain ☐</td> <td style="border: none;">Over/Under tolerance ☐</td> </tr> <tr> <td style="border: none;">Equip/Tooling ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;">Cracks ☐</td> <td style="border: none;">Broken/Damage/Defect ☐</td> <td style="border: none;">Weld ☐</td> <td style="border: none;">Part Incorrect ☐</td> </tr> <tr> <td style="border: none;">Handling/Pre ☐</td> <td style="border: none;">Training ☐</td> <td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td> <td style="border: none;">Inspection Incomplete/Unqualified ☐</td> <td style="border: none;">Wrong Stock Pulled ☐</td> <td style="border: none;">Part Lost/Missing ☐</td> </tr> <tr> <td style="border: none;">Material ☐</td> <td style="border: none;">Use for Testing ☐</td> <td style="border: none;">Cuffs ☐</td> <td style="border: none;">Contamination ☐</td> <td style="border: none;">Out of Sequence ☐</td> <td style="border: none;">Part Moved ☐</td> </tr> <tr> <td style="border: none;">Internal Transport ☐</td> <td style="border: none;">Poor Information ☐</td> <td style="border: none;">Crushing ☐</td> <td style="border: none;">Countersink ☐</td> <td style="border: none;">Off-set ☐</td> <td style="border: none;">Drawing ☐</td> </tr> <tr> <td style="border: none;">Tribal Knowledge ☐</td> <td style="border: none;">Rushing ☐</td> <td style="border: none;">Heat Treat ☐</td> <td style="border: none;">Cut Too Short ☐</td> <td style="border: none;">Mislabeled ☐</td> <td style="border: none;">Finish ☐</td> </tr> <tr> <td style="border: none;">LOA ☐</td> <td style="border: none;">Product Improvement ☐</td> <td style="border: none;">Wave/Twist in Tube ☐</td> <td style="border: none;">Instructions Incomplete/Unclear ☐</td> <td style="border: none;">Fit/Function ☐</td> <td style="border: none;">Misread ☐</td> </tr> <tr> <td style="border: none;">Substation ☐</td> <td style="border: none;">Process Improvement ☐</td> <td style="border: none;">Marks/Chatter ☐</td> <td style="border: none;">Drill Holes ☐</td> <td style="border: none;">Misaligned/off center ☐</td> <td style="border: none;">Turning Sequence ☐</td> </tr> <tr> <td style="border: none;">Past Expiry Date ☐</td> <td style="border: none;">Manufacturing Process ☐</td> <td colspan="4" rowspan="2" style="border: none;"></td> </tr> <tr> <td style="border: none;">Misidentified ☐</td> <td style="border: none;">Past Due ☐</td> </tr> </table>			Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐					Misidentified ☐	Past Due ☐	FAULT CATEGORY OTHER : ☐		
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	8/30/2016	DPD	JAG
2	16-0279	-1 CH'D DIM WAS .38 IS .6, ADDED NOTE $\triangle$ -3 DELETED.	1/12/2017	RJC	JAG
3	17-0162	ADDED INK STAMP T/N ON EACH -9 FLAG NOTE. -1 CH'D DIM WAS .6 IS .3-.7.	6/23/2017	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186984 MJS
18-11-23

NOTES:

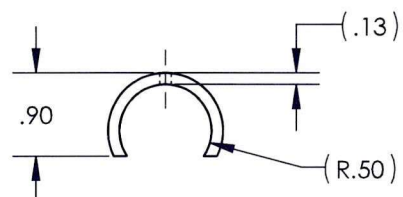
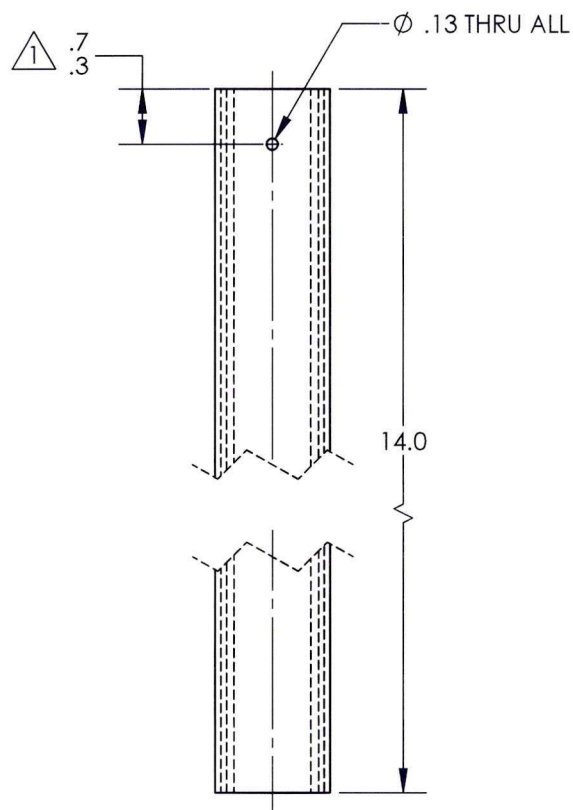
1. PART OF KIT RBT18561
- $\triangle$ INK STAMP T/N ON EACH -9 FLAG.

DART AEROSPACE	
TITLE MAIN ROTOR PITCH LINK PROTECTORS	
DWG NO. RBT18034	REV 3
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	BELL 407
APPROVED: GILBERT	
SCALE 1:6	DATE 8/22/2016
SHEET 1 OF 2	

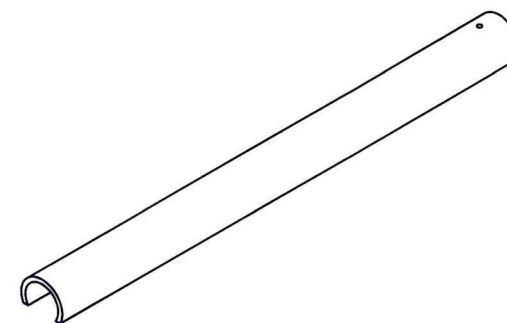
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	4	HOSE	PVC	KUR BW100 (PACIFIC RUBBER) MODIFIED	2
		B/O	-5	4	LANYARD	COATED STEEL	Ø1/16" X 5" (CARR LANE #CL-2-C)	1
		B/O	-7	8	FERRULE	COPPER	Ø1/16" (CARR LANE # CL-2-F)	1
		B/O	-9	4	REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	1

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2	16-0279	-1 CH'D DIM WAS .38 IS .6, ADDED NOTE $\triangle$ 1	1/12/2017	RJC	JAG
3	17-0162	-1 CH'D DIM WAS .6 IS .3-.7.	6/23/2017	DPD	JAG



(-1)
HOSE



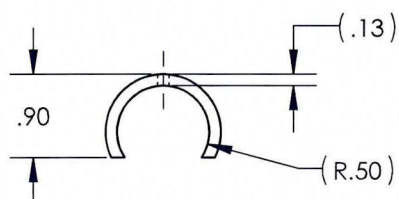
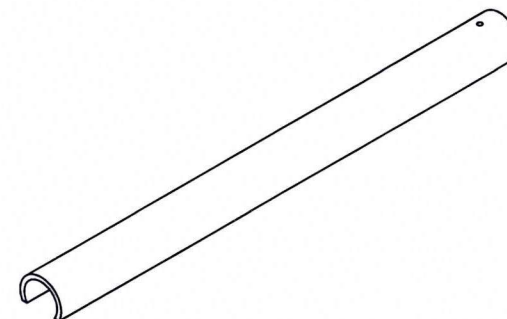
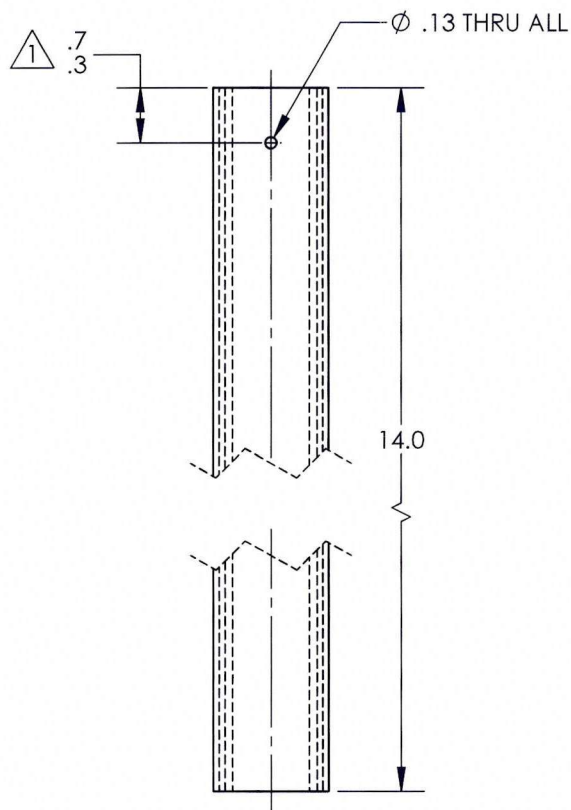
NOTE:

$\triangle 1$ DRILL HOLE BETWEEN TWO RIBS.

DART AEROSPACE	
TITLE MAIN ROTOR PITCH LINK PROTECTORS	
DWG NO. RBT18034-1	REV 3
MAT'L PVC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FEAT	.XXX $\pm$.010 FRACTIONS $\pm$ 1/8
TREAT	.XX $\pm$.03 ANGLES $\pm$ 1°
FINISH	.X $\pm$.1 SURFACES = 125✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	BELL 407
APPROVED: GILBERT	
SCALE 1:2	DATE 8/22/2016 SHEET 2 OF 2

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(-1)
HOSE

NOTE:

$\triangle$ 1 DRILL HOLE BETWEEN TWO RIBS.

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TITLE MAIN ROTOR PITCH LINK PROTECTORS	
DWG NO. RBT18034-1	REV 3
MAT'L PVC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FEAT TREAT FINISH	.XXX $\pm$.010 FRACTIONS $\pm$ 1/8 .XX $\pm$.03 ANGLES $\pm$ 1° .X $\pm$.1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	BELL 407
APPROVED: GILBERT	
SCALE 1:2	DATE 8/22/2016 SHEET 2 OF 2